



Dart Aerospace Ltd.
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646.3301
Job Sheet 181952



Part No: 646.3301

Job Qty: 7 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/14/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3300 REV NC3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER
DWG NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	7 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Stores/Pkg-2		AUG 23 2018
110	Packaging	7 pcs	9/7/18	9/7/18	0.00	0.00	Packaging1-1		AUG 23 2018
120	Small Fab	7 pcs	9/7/18	9/7/18	0.00	9.72	Small Fab-1		SEP 13 2018
130	QC	7 pcs	9/7/18	9/7/18	0.00	0.00	QC5		SEP 14 2018
140	Packaging	7 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		SEP 14 2018
150	QC21-SA	7 Ea	9/7/18	9/7/18	0.00	0.00	QC21		SEP 14 2018

Part Op 120 - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying
Descriptions: surfaces shown on dwg per note 7. exp. date: 03/20

140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly	7 Ea (1 ea)	90-Start up Operation	5060629
646.3311	RH Half - Upper Cutter Assembly	7 Ea (1 ea)	90-Start up Operation	5044676
646.3312	Center Plate	7 Ea (1 ea)	90-Start up Operation	5060083X2 5043341 X5
646.3313	Upper Guide	7 Ea (1 ea)	90-Start up Operation	5054913X1 5043381 X6
646.3314	Blade 5041002 X4	7 Ea (1 ea)	90-Start up Operation	5041002X1 505248 X2
646.3315	Blade	7 Ea (1 ea)	90-Start up Operation	5051528
646.3316	Blade	7 Ea (1 ea)	90-Start up Operation	5042403X1 5053063X6
AN3-12A	Bolt	14 Ea (2 ea)	90-Start up Operation	5048376
AN3-14A	Bolt	7 Ea (1 ea)	90-Start up Operation	5068652
MS21042L08	Nut	126 Ea (18 ea)	90-Start up Operation	5044237
MS21042L3	Nut	21 Ea (3 ea)	90-Start up Operation	5089340
MS27039-08-19	Screw	126 Ea (18 ea)	90-Start up Operation	5044235
NAS1149F0332P	Washer	42 Ea (6 ea)	90-Start up Operation	5003660
NAS1149FN832P	Washer	252 Ea (36 ea)	90-Start up Operation	501583364X151

646-3301

S104453

REV: N/C3

5/29



Container No: S104453

Part: 646.3301

Job No: 181952

Serial No/Batch: S104453

Revision:

Inspector:

Exp Date:

Instructions:

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Date: 06/23/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.3310	7	7	0
	646.3311	7	8	0
	646.3312	7	22	0
	646.3313	7	15	0
	646.3314	7	17	0
	646.3315	7	17	0
	646.3316	7	18	0
	AN3-12A	14	122	0
	AN3-14A	7	129	0
	MS21042L08	126	3,146	0
	MS21042L3	21	3,988	0
	MS27039-08-19	126	654	0
	NAS1149F0332P	42	93	0
	NAS1149FN832P	252	2,554	0
Part Specifications				
Specifications could not be found.				

Plex 8/20/18 2:16 PM dart.quirion.sonia